

Patent claims

1. A method of producing a key blank from a workpiece comprising incorporating a plurality of profiles in a workpiece (6) as grooves (2.1' - 2.5'), wherein each of the plurality of profiles is formed in accordance with the geometry of the tool used to form the groove.

2. The method as claimed in claim 1, wherein the grooves (2.1' - 2.5') are milled in a groove width (B') and groove depth (T') of a predetermined profile which groove widths (B') and groove depths (T') correspond approximately to the groove width (B) and groove depths (T) of the tool forming the groove.

3. The method as claimed in claim 1 or 2, wherein, in order to produce the key blank, the groove flanks (4.1' - 4.3') of the profile recesses (2.1' - 2.5') are incorporated approximately perpendicularly to the workpiece surface.

4. The method as claimed in claim 1 or 2, wherein, in order to produce the key blank, the groove roots (5.1') of the profile recesses (2.1' - 2.5') are incorporated approximately parallel to the workpiece surface.

5. Method as claimed in claim 1 or 2, wherein, in order to produce the key blank, the groove flanks (4.1' - 4.3') of the profile recesses (2.1' - 2.5') are incorporated approximately in

accordance with the angle(s) of the milling cutter sides (7.1') of the milling cutter(s) used relative to the workpiece surface.

6. The method as claimed in claim 1 or 2, wherein, in order to produce the key blank, the groove roots (5.1') of the profile recesses (2.1' - 2.5') are incorporated in the workpiece (6) approximately so as to be comparable with the geometry of the milling cutter tip (7.2').

7. The method as claimed in claim 1, wherein profiles of a conventional key (1) consisting of a plurality of grooves (2.1 - 2.5) are converted to grooves (2.1' - 2.5'), which have a shape optimized in accordance with the geometry of the milling cutter(s) (3'), a width (B') and a depth (T') of the profile recesses corresponding approximately to the width (B) and depth (T).

8. The method as claimed in claim 1, wherein a conventional profile of a key (1) is read in via a copying or reading device, the individual grooves (2.1 - 2.5) or webs, which are also designed as positive or negative bevels or radial profile grooves, being converted into a shape optimized in accordance with the geometry of the milling cutter(s) (3'), with approximately the same width (B, B') and depth (T, T'), and being milled or incorporated in the workpiece (6).

9. The method as claimed in claim 1, wherein a multiplicity of conventional profiles of keys (1) are stored, each profile being converted into a shape optimized in accordance with the geometry of the milling cutter(s) (3').

10. The method as claimed in claim 1, wherein a multiplicity of conventional individual profile sections, grooves or recesses are stored, each profile section being converted into a shape optimized in accordance with the geometry of the milling cutter(s) (3').

11. The method as claimed in claim 1, wherein a key profile is composed of and calculated from a multiplicity of individual profile sections, grooves or recesses.

12. The method as claimed in claim 1, wherein the stored key profiles and/or profile sections are already converted into a shape optimized in accordance with the geometry of the milling cutter(s) (3').